

Date: Monday, 6/12/2006 3:37:12 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR PROTECTOR AFT RH
Job Number	: 27511		
Estimate Number	: 11235		
P.O. Number	: N/A	Part Number	: D32814
This Issue	: 6/12/2006 S.O. No. : N/A	Drawing Number	: D3281 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 26356	Material	: N/A
Written By	: <i>See Comment Below</i>	Due Date	: 6/30/2006 Qty: 20 Um: Each
Checked & Approved By	: <i>06 06 13 n</i>		
Comment	: Est Rev: A 04.07.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1493

Description: Floor Protector Aft, RH

Possible Supplier: Delastek

Certificate of Conformity is required

2.0	D32814P	Floor Protector, Aft RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Floor Protector Aft, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 13 Date: 06/07/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:37:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT RH

Job Number: 27511

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

(Signature) 06/07/13 *(20)*

Job Completion



UL 8007-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

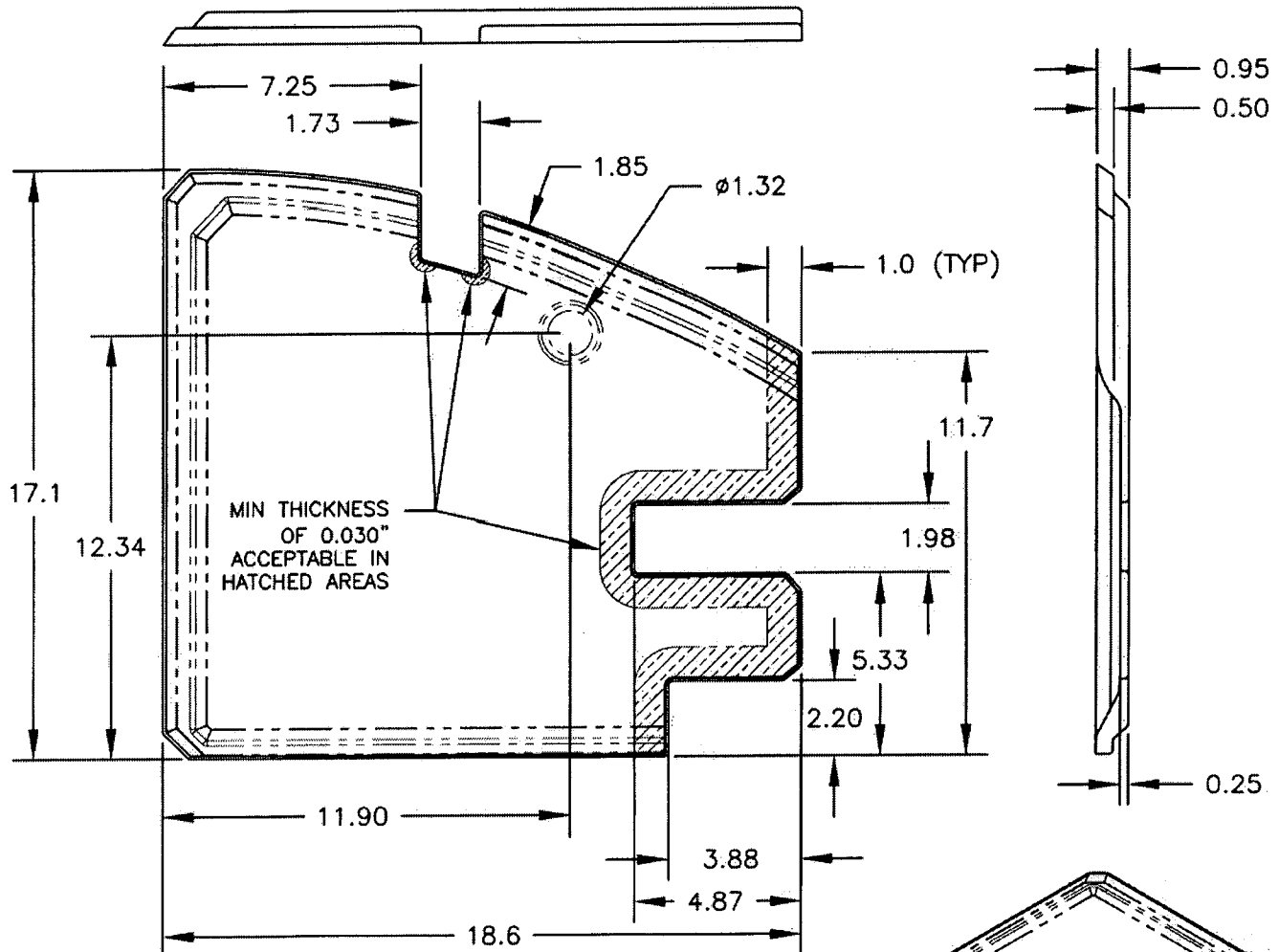
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

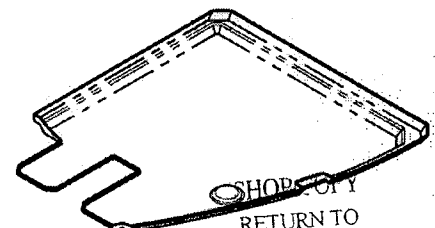
QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	



RELEASED
05.12.01



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WITHOUT NOTICE
WORK ORDER
NO. 27511

D3281-1 FLOOR PROTECTOR, FWD LH

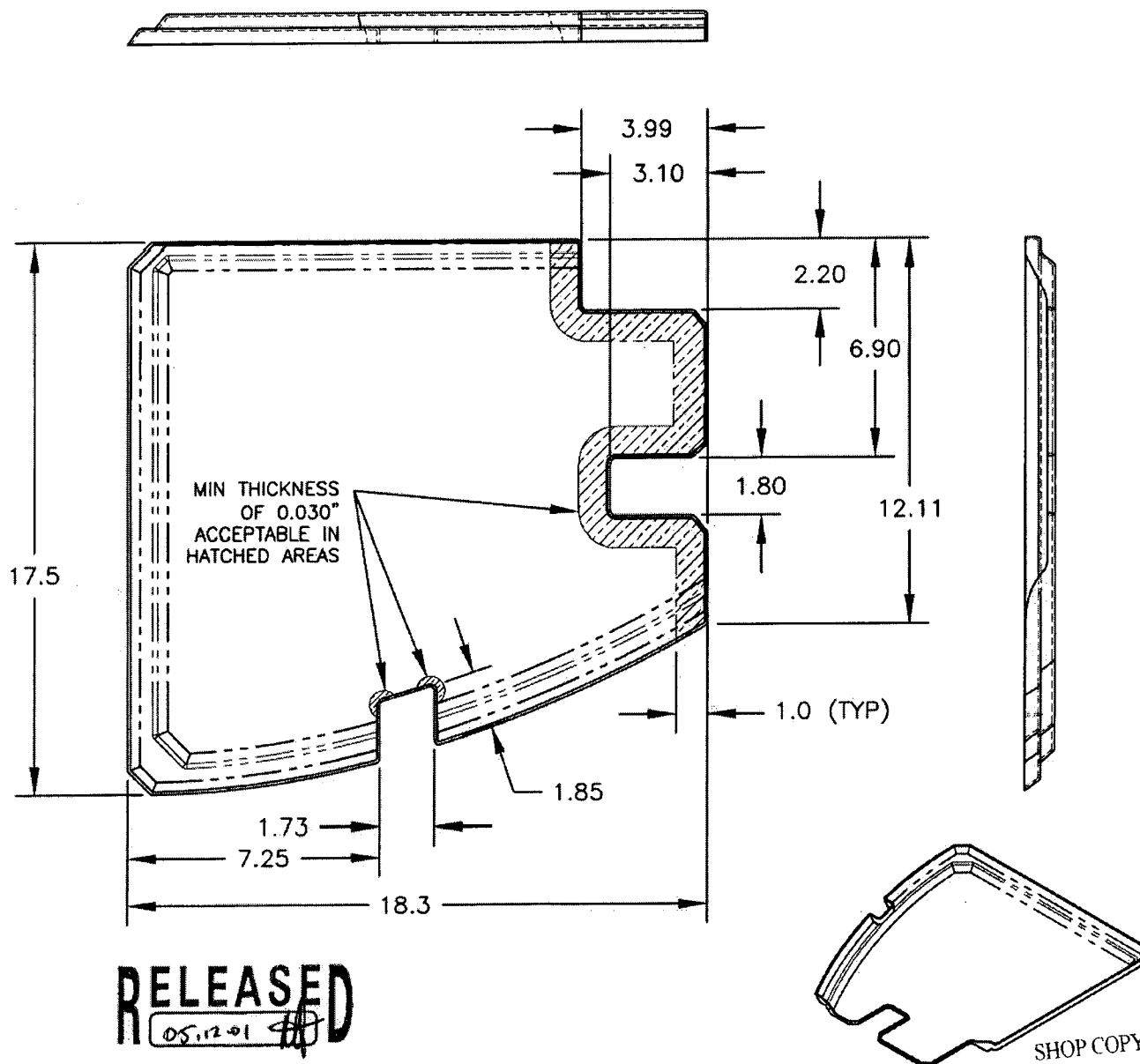
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

**RELEASED**
05.12.01 *[Signature]***D3281-2 FLOOR PROTECTOR. FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

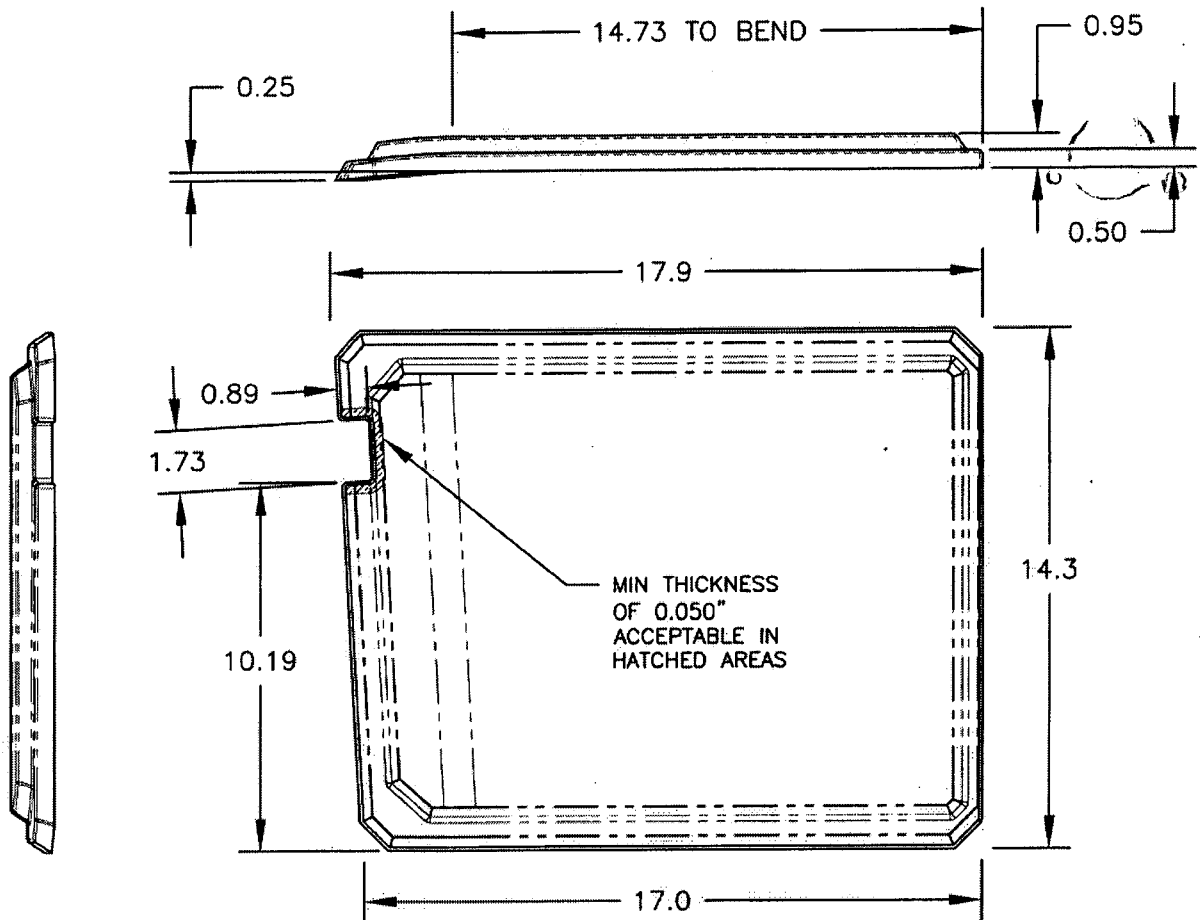
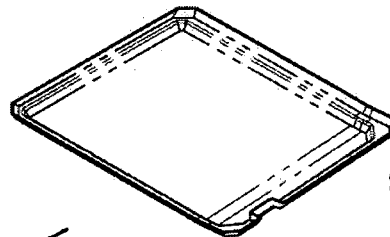
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. 8 SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**
05.12.01. *[Signature]*

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	10722
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
07/07/06	15/06/06	4716	C. Lavoie		PO00001493		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
20	0	20	DKC134-0047	Floor Protect Part 4 N° D3281-4 (F6006) Selon dessin D3181 Rev.: B JOB: 36895 QTÉ: 20 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department



AQ-357

Date: Jeudi, 2006-06-22 10:51:22
Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : FLOOR PROTECTOR AFT, LH	
Numéro Job : 36895		Numéro Article : DKC134-0047	
Numéro Soumission : 2386		Numéro Dessin : D3281	
Numéro B.A. :		Projet Numéro : DKC134	
Cette fois : 2006-06-22	No. B.V. :	Révision dessin : B	
Prsht Rev. : NC		Matériel : F6006	
Prem. fois : - -	Type :	Date Dûe : 2006-06-29	Qté: 20 Udm: UNITE
Job précédente : 34176			
Écrit par :			
Vérifié & Approuvé par :			
Commentaires : N° de pièce: D3281-4			

Process Sheet Rév.: 00 Création du premier

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 APL0016 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentaire Qty.: 0.167 UNITE(s)/l' " Lexan F6006 Noir N° 700

APL0016

N° de Lot:

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Bon achat: 5490

2.0 SÉCHAGE/ANEAL

Commentaire Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 5145

3.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentaire Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 20 Date: 5-7-06 Sceau:

Quantité: _____ Date: _____ Sceau: _____



Date: Jeudi, 2006-06-22 10:51:22
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 36895

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0047

Numéro Job:



Séq.: Machine ou Opération: Description:

4.0

THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART



Commentaire Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-4 à l'aide du moule N° D3281-4T1 sur le
thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 20 Date: 5-7-06 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-4 à l'aide du gabarit de trimage N° D3281-4T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 20 Date: 6-7-06 Sceau: SB

Quantité: _____ Date: _____ Sceau: _____

6.0


INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 20 Date: 7-11-06 Sceau: 

7.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Job: 36895

Numéro Article: DKC134-0047

Numéro Job:



Séq.:

Machine ou Opération:

Description :

N° de pièce: D3281-4

N° de Job: _____

Date de fabrication: _____

Sceau d'inspection.

Quantité: 20 Date: 7-07-06 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs


EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3281-4

Date de fabrication: _____

N° de job: _____

Quantité: 20 Date: 7/7/06 Sceau: 

Quantité: _____ Date: _____ Sceau: _____